

To ship ASAP.

Work Order ID 141365

141365

Page 1

February 03, 2016 4:48:38 PM

Item ID: D205-633-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ - 39" Extended Height Gear, Isolair Tank Comp., Fits LH or RH

Start Date: 2/3/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/24/2016 Req'd Qty: 2.00

2

Customer:

Reference:

20160203

Approvals: Process Plan: SAA

Date:

Tooling:

Date:

Run Start

NR1

QC: _____

Date:

SPC (Y/N): _____

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D205-633

C

DAS
26
9-89

0.00

MW 16-02-08

100

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D205-633-015 CHG002

2

DAS
26
9-89

FEB 09 2016

2

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2x

DAS
26
9-89

FEB 09 2016

DAS
27
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

2

DAS
26
9-89

FEB 09 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
OTHER : ☐																																																																																																																															

Work Order ID 141365***141365***

Page 2

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Item ID: D205-633-015 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ - 39" Extended Height Gear, Isolair Tank Comp., Fits LH or RH
Start Date: 2/3/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 2/24/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-015 Location: <u> </u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

FEB 09 2016

MLJ

20160209

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 141365

141365

Parent Item: D205-633-015

D205-633-015

Parent Item Name: Heli-Access-Step™ - 39" Extended Height Gear, Isolair Tank Comp., Fits LH or RH

Start Date: 2/3/2016

Required Date: 2/24/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B02.07.31Re-FormatKJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-10A		Purchased	No			110	Each	95.0000	1	2			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

2 ***AN4-10A***
Bolt

Location	Loc Qty	Loc Code
CA	13	
M129682	13	
ST345	82	
131677	5	
M133234	77	

DAS
28
9-89

DAS
26
27
9-89

AN4-14A		Purchased	No			110	Each	650.0000	1	2			
---------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

2 ***AN4-14A***
Bolt

Location	Loc Qty	Loc Code
FG	5	
122141	5	
over003	500	
M133998	500	
ST344	145	
M133316	15	
M133769	130	

DAS
28
9-89

DAS
26
27
9-89

AN44-7A		Purchased	No			110	Each	14.0000	1	2			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

2 ***AN44-7A***
Eyebolt

Location	Loc Qty	Loc Code
ST339	14	
m125842	8	
m131947	6	

DAS
28
9-89

DAS
26
27
9-89
FEB 08 2016

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Work Order ID: 141365

141365

Parent Item: D205-633-015

D205-633-015

Parent Item Name: Heli-Access-Step™ - 39" Extended Height Gear, Isolair Tank Comp., Fits LH or RH

Start Date: 2/3/2016

Required Date: 2/24/2016

AN4-5A Purchased No 110 Each 183.0000 Start Qty: 2.00 Required Qty: 2.00

2 ***AN4-5A***
BOLT

DAS
28
9-89

Location	Loc Qty	Loc Code
CA	55	
m129682	55	
over003	100	
m134039	100	
ST345	28	
m133064	28	

24

AN4-6A Purchased No 110 Each 1,177.000 3 6

2 ***AN4-6A***
BOLT

DAS
28
9-89

Location	Loc Qty	Loc Code
CA	143	
M128403	43	
M130851	100	
ST345	1034	
M133316	18	
M133363	24	
M133790	992	

6x

AN4-7A Purchased No 110 Each 129.0000 2 4

2 ***AN4-7A***
Bolt

DAS
28
9-89

Location	Loc Qty	Loc Code
over003	100	
m133790	100	
ST325	29	
m131320	29	

4

FEB 08 2016

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Work Order ID: 141365

141365

Parent Item: D205-633-015

D205-633-015

Parent Item Name: Heli-Access-Step™ - 39" Extended Height Gear, Isolair Tank Comp., Fits LH or RH

Start Date: 2/3/2016

Required Date: 2/24/2016

AN5-14A

Purchased

No

110

Each

38.0000

Start Qty: 2.00

Required Qty: 2.00

DAS
26
9-89

AN5-14A

Bolt

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST338

38

m133990

38

D2022-101

Manufactured

No

110

Each

133.0000

2

4

**

DAS
26
9-89

D2022-101

Spacer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST001

87

132703

87

ST012a

46

140201

46

D2022-103

Manufactured

No

110

Each

30.0000

2

4

**

DAS
26
9-89

D2022-103

Spacer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST001

30

139455

30

D2562-005

Manufactured

No

110

Each

11.0000

1

2

**

DAS
26
9-89

D2562-005

Strut 29.00"

DAS
28
9-89

Location

Loc Qty

Loc Code

Mezz

11

23224

5

43745

3

93910

3

D2563

Manufactured

No

110

Each

0.0000

1

2

**

DAS
26
9-89

D2563

Step Weldment Assembly

X2 B140777

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Shop Packet Print

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Picklist Print

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Page 4

Work Order ID: 141365

141365

Parent Item: D205-633-015

D205-633-015

Parent Item Name: Heli-Access-Step™ - 39" Extended Height Gear, Isolair Tank Comp., Fits LH or RH

Start Date: 2/3/2016

Required Date: 2/24/2016

D2565-301

Manufactured No

110 Each

8.0000

Start Qty: 2.00

Required Qty: 2.00

D2565-301

Strut

**

1 2
1X B23224

DAS 26 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

Mezz

8

17670

2

20818

2

20848

1

59624

3

1X

D2565-303

Manufactured No

110 Each

7.0000

1

2

D2565-303

Strut

**

DAS 26 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

Mezz

7

17671

1

20849

2

23227

2

59622

2

2X

DAS 26 27 9-89

D2565-305

Manufactured No

110 Each

8.0000

1

2

D2565-305

Strut

**

FEB 00 2016

DAS 28 9-89

Location

Loc Qty

Loc Code

Mezz

8

20850

3

23228

2

59619

3

2X

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Work Order ID: 141365

141365

Parent Item: D205-633-015

D205-633-015

Parent Item Name: Heli-Access-Step™ - 39" Extended Height Gear, Isolair Tank Comp., Fits LH or RH

Start Date: 2/3/2016

Required Date: 2/24/2016

D2565-307

Manufactured No

110

Each

10.0000

Start Qty: 2.00

Required Qty: 2.00

1 2

**

DAS
26
27
9-89

2 ~~D~~ *D2565-307*

Strut

DAS
28
9-89

buggies

Location

Loc Qty

Loc Code

Mezz

10

17673

1

20851

1

23229

2

43749

1

59617

5

D2565-309

Manufactured No

110

Each

10.0000

1

2

**

DAS
26
27
9-89

2 ~~D~~ *D2565-309*

Strut

DAS
28
9-89

Location

Loc Qty

Loc Code

Mezz

10

17674

1

20852

3

23230

1

59616

3

93884

2

D3165-1

Manufactured No

110

Each

12.0000

1

2

**

DAS
26
27
9-89

2 ~~D~~ *D3165-1*

Support Arm

DAS
28
9-89

Location

Loc Qty

Loc Code

ST366

12

115853

4

119024

2

23234

5

43761

1

FEB 08 2016

Picklist Print

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Work Order ID: 141365

141365

Parent Item: D205-633-015

D205-633-015

Parent Item Name: Heli-Access-Step™ - 39" Extended Height Gear, Isolair Tank Comp., Fits LH or RH

Start Date: 2/3/2016

Required Date: 2/24/2016

NAS1149D0463J

Purchased

No

110

Each

Start Qty: 2.00
16 32

Required Qty: 2.00

NAS1149D0463.J

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	397	
M129390	41	
M132035	356	
ST260a	1999	
M134039	1999	
ST263	1301	
M134039	1301	
ST269	1349	
M130799	361	
M132317	100	
M132677	888	

DAS
26
9-89

DAS
27
9-89

NAS1149D0563J

Purchased

No

110

Each

1,286.000 3 6

NAS1149D0563.J

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	53	
m125807	53	
ST260a	900	
m133769	400	
m133990	500	
ST263	230	
m133363	54	
m133938	176	
ST269	103	
m128257	103	

DAS
26
9-89

FEB 08 2016

DAS
27
9-89

5.0 PARTS LISTS

DAS

28

9-89

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: C

Date: 13.12.13